

In the Claims:

Please cancel claims 1-15, without prejudice, and add new claims 16-32. The status of all claims is as follows:

1-15 (Cancelled)

16. (New) A corn zein resin article formed by a process comprising:

(a) forming a wet corn zein resin comprising:

(i) corn zein, and

(ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

(b) cold rolling the wet zein resin to provide a wet zein resin sheet of a predetermined thickness;

(c) drying the wet zein resin sheet at a temperature of about 40° C to about 90°C and a relative humidity of about 5% to about 20% to provide a dry zein resin;

(d) comminuting the dry zein resin to form particles of the dry zein;

(e) forming the dry zein resin of step (d) under heat and pressure into the article.

17. (New) A corn zein resin pellet formed by a process comprising:

(a) forming a wet corn zein resin comprising:

(i) corn zein, and

(ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

(b) cold rolling the wet zein resin to provide a wet zein sheet of a predetermined thickness;

(c) drying the wet zein resin sheet at a temperature of about 40° C to about 90° C and a relative humidity of about 5% to about 20% to provide a dry zein resin;

(d) optionally comminuting the dry zein resin to form particles of the dry zein;

(e) extruding the dry zein resin of step (c) or step (d) to form the pellet.

18. (New) A dry zein resin powder formed by a method comprising:

(a) forming a wet corn zein resin comprising:

(i) corn zein, and

(ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

(b) cold rolling the wet zein resin to provide a wet zein sheet of a predetermined thickness;

(c) drying the wet zein resin sheet at a temperature of about 40° C to about 90° C and a relative humidity of about 5% to about 20% to provide a dry zein resin;

(d) comminuting the dry zein resin to form the dry zein resin powder.

19. (New) A corn zein resin article formed by a method comprising:

(a) forming a wet corn zein resin comprising:

(i) corn zein, and

(ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

(b) cold rolling the wet zein resin to provide a wet zein sheet of a predetermined thickness;

(c) drying the wet zein resin sheet at a temperature of about 40° C to about 90° C and a relative humidity of about 5% to about 20% to provide a dry zein resin;

(d) optionally comminuting the dry zein resin to form particles of the dry zein;

(e) forming the dry zein resin of step (c) or step (d) into the article.

20. (New) The article of claim 19 wherein the step (e) of forming comprises:

- (i) melting or softening the dry zein resin of step (c) or step (d) and cold rolling the melted or softened dry zein resin to form a sheet;
- (ii) applying heat and pressure to the sheet of step (i) to form the article.

21. (New) The article of claim 19 wherein the step (e) of forming comprises:

- (i) extruding the dry zein resin of step (c) or step (d) into pellets;
- (ii) forming the pellets of step (i) into the article.

22. (New) The article of claim 21 wherein the step (ii) of forming the pellets into the article comprises extruding.

23. (New) The article of claim 21 wherein the step (ii) of forming the pellets into the article comprises:

- (A) extruding the pellets of step (i) into sheets;
- (B) applying heat and pressure to the sheets of step (A) to form the article.

24. (New) The article of claim 21 wherein the step (e) of forming comprises compression molding the dry zein resin of step (c) or step (d) into the article.

25. (New) A corn zein resin sheet or film formed by the process comprising:

- (a) forming a wet corn zein resin comprising:
  - (i) corn zein, and
  - (ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

(b) cold rolling the wet zein resin to provide a wet zein sheet of a predetermined thickness;

(c) drying the wet zein resin sheet at a temperature of about 40° C to about 90° C and a relative humidity of about 5% to about 20% to provide a dry zein resin;

(d) optionally comminuting the dry zein resin to form particles of the dry zein;

(e) forming the dry zein resin of step (c) or step (d) into the sheet or film.

26. (New) The sheet or film of claim 25 wherein the step (e) of forming comprises:

(i) melting or softening the dry zein resin of step (c) or step (d) and cold rolling the melted or softened dry zein resin to form an intermediate sheet;

(ii) applying heat and pressure to the intermediate sheet of step (i) to form the sheet or film.

27. (New) The sheet or film of claim 25 wherein the step (e) of forming comprises:

(i) extruding the dry zein resin of step (c) or step (d) into pellets;

(ii) forming the pellets of step (i) into the sheet of film.

28. (New) The sheet or film of claim 27 wherein the step (ii) of forming the pellets into the sheet or film comprises:

(A) extruding the pellets of step (i) into intermediate sheets;

(B) applying heat and pressure to the intermediate sheets of step (A) to form the sheet or film.

29. (New) A corn zein resin film formed by the method comprising:

(a) forming a wet corn zein resin comprising:

- (i) corn zein, and
- (ii) about 20 to about 100 parts by weight of a fatty acid, per 100 weight parts of the corn zein;

- (b) cold rolling the wet zein resin to provide a wet zein sheet of a predetermined thickness;

- (c) biaxially orienting the wet zein resin sheet;

- (d) forming the biaxially oriented sheet into the film.

30. (New) The film of claim 29 wherein the step (d) of forming the biaxially oriented sheet into the film comprises air drying the biaxially oriented sheet and hot pressing the air dried sheet to produce the film.

31. (New) The film of claim 29 wherein the step (d) of forming the biaxially oriented sheet into the film comprises:

- (i) blowing the biaxially oriented sheet into an intermediate film;

- (ii) air drying the intermediate film;

- (iii) hot pressing the intermediate film to produce the film.

32. (New) The film of claim 29 wherein the step (c) of biaxially orienting the wet zein resin sheet comprises transversely stretching the wet zein resin sheet.